

Mould cavity filling device for mould table of press, esp. building brick press

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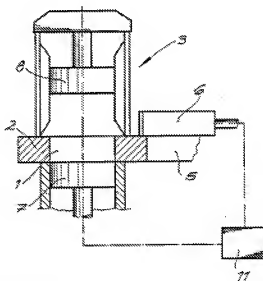
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Abstract of DE19506636

During the travelling back of the filling slide (6) drawn up over the mould cavity (1), the lower pressure ram (7) is synchronously raised by a predetermined amount of travel.

Consequently, the filling slide takes back with it highly pressurised moulding composition from the cavity in an increasing volume. After the slide has travelled back the lower pressure ram is withdrawn. When the withdrawal is complete the height of the mould composition lies flush with the plane of the mould table.



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[0001] With molding compound, with a filling table and a filling slidegate valve, that in the course of the filling procedure on the aligning form table to over the die cavity and molding compound moves the invention relates to forward a filling apparatus to the filling of a form cavity in the form of a press, in particular press for the component industry, at the bottom into the die cavity emptied and with press-laterally at least an upper and a lower press stamp retractable into the die cavity for double-sided consolidating of the molding compound.

State of the art

[0002] With such filling devices the filling slidegate valve is needed regularly filled with more molding compound than for the blocks which can be manufactured, so that the die cavity cannot take up the entire molding compound existing in the filling slidegate valve. Therefore a part of the molding compound remains in the filling slidegate valve. In such filling it disturbs that a filling of the filling slidegate valve leads beyond the necessary molding compound to a compressing of this molding compound in the die cavity. To receive thus that even density over the stone cross section of impaired, which is necessary, in order blocks from perfect quality also within the edge ranges. The problems around an uneven molding compound compression become all the larger, the blocks which can be manufactured are the larger. That applies in particular to stone elements, as they find in the industrial building use, because such stone elements have unusually large lengthening, spreading and Dickenabmessungen. - Here the invention begins.

Object

[0003] The invention is the basis the object, one would genericin accordance with-eat filling apparatus to create, those in response of to blocks which can be manufactured and/or. Going by always it ensures a well-defined filling of the form cavity to stone elements that an even compaction is reached by means of the stone cross section.

[0004] This solve the problem the invention with a filling device of the initially described embodiment by the fact that in the course of going back the filling slidegate valve moved forward over the die cavity the lower press stamp is raised synchronously around a given stroke measure and thus the filling slidegate valve from the die cavity takes back pushed up molding compound increasingly also, and that after going back the filling slidegate valve the lower press stamp up to aligning the molding compound-highest with the form table level is gone back and afterwards the Pressvorgang takes place. - The invention proceeds from the phenomenon that the die cavity takes up assigned side very much in the course of the filling course at its filling slidegate valve to starting position more molding compound than at its filling slidegate valve in end position assigned side. This multi-admission at molding compound can amount to with large stone elements 80 N to 100 N and removes almost evenly from that the filling slidegate valve in starting position assigned side of the form cavity up to its opposite filling slidegate valve in end position assigned side, although the molding compound filled into the die cavity aligns after the filling course with the form table level. This molding compound distribution uneven in weight-related regard is to be due obviously to a compressing of the molding compound by the molding compound still in the filling slidegate valve, which by that side of the form cavity assigned constantly decreases assigned side of the form cavity to the filling slidegate valve in starting position to that the filling slidegate valve in end position. Therefore an

▲ top even molding compound compression can be achieved by means of the entire stone cross section only then, if an appropriate portion of molding compound within that form hollow range is again removed, in which as it were a molding compound overstocking took place, proportional to compressing taken place. That succeeds to the invention after teachings in surprisingly simple way by the filling slidegate valve, if the lower press stamp in the course of going back the filling slidegate valve pushes the molding compound up synchronously to the filling slidegate valve movement from the die cavity, so that the filling slidegate valve clears away and also takes molding compound back increasingly, thus as it were a wedge-shaped molding compound layer from the die cavity is removed, whose is largest wedge-broad on the side of the form cavity, which is assigned to the again reached starting position of the filling slidegate valve. The filling slidegate valve and the lower press stamp under inserting a computer speed-controlled or away-controlled, anyhow is in such a manner carried out a control that each filling slidegate valve position is in such a manner assigned with going back filling slidegate valve a given stamp position with raising press stamp that an evenly increasing molding compound erosion takes place also if the starting positions differ from filling slidegate valve on the one hand and lower press stamp on the other hand from case to case. By it that even filling of the form cavity is reached, which an even molding compound compression ensured, even if the molding compound aligns practically only at the side of the form cavity with the form table level, at which the filling slidegate valve is in end position, lasts the molding compound because of the side of the form cavity, which is assigned to the filling slidegate valve in starting position, clearly below the form table level is, so that as it were a wedge-shaped empty space between the form table level and the molding compound filling of the proportional itself in the course filling procedure adjusting and removing and/or. increasing compressing is given.

Aufführungsbeispiel

[0005] In the following the invention is details described on the basis only a design representing an embodiment; show:

[0006] Fig. 1 a filling device according to invention with schematically suggested press in side view and before the filling procedure,

[0007] Fig. 2 a cutout from the article after Fig. 1 filling slidegate valve moved forward after the filling procedure also in end position.

[0008] Fig. 3 the article after Fig. 1 with going back filling slidegate valve and raising lower press stamp and

[0009] Fig. 4 the article after Fig. 1 after in starting position gone back filling slidegate valve and in starting position for the Pressvorgang gone back lower press stamp.

[0010] In the figures a filling device is represented to the filling of a form cavity 1 in the form table 2 of a press 3 for the component industry, with molding compound 4. Component industry means prefers the production of lime sandstones and in particular stone elements with relatively large lengthening, spreading and Dickenabmessungen to the inset in the z. B. Industrial building. The filling device exhibits a filling table 5 and a filling slidegate valve 6, in the course of the filling procedure on the aligning form table 2 to over the die cavity 1 moves forward and molding compound 4 at the bottom into the die cavity 1 emptied. The press 3 exhibits at least an upper and a lower 1 press stamp 7, 8 retractable into the die cavity for double-sided consolidating of the molding compound 4. After the filling of the form cavity 1 the filling slidegate valve 6 goes back into its starting position. In the course of going back the filling slidegate valve 6 moved forward over the die cavity 1 the lower press stamp 7 is raised synchronously and continuous around by the drive of the filling slidegate valve 6 given stroke measure. Thus the filling slidegate valve 6 from the die cavity takes 1 pushed up molding compound back 4 increasingly also, so that a wedge-shaped molding compound erosion is reached. After going back the filling slidegate valve 6 into its starting position becomes the lower press stamp 7 up to aligning the molding compound-highest 9 and/or. the highest molding compound edge gone back on that the filling slidegate valve 6 in end position assigned side of the form cavity 1 with the form table level. Thus a wedge-shaped empty space 10 between the molding compound filling and the form table level with largest wedge-broad on that develops for the filling slidegate valve 6 in its starting position assigned side of the form cavity 1, because in the course of the filling of the form cavity 1 a compressing and a increased molding compound admission took place there, which decrease almost evenly up to the side of the form cavity 1, which is assigned to the end position of the moved forward filling slidegate valve 6. In the course of the following Pressvorganges an even compaction of the stone element concerned reaches itself by this wedge-shaped empty space formation above the molding compound filling by means of the entire stone cross section. The filling slidegate valve 6 and the lower press stamp 7 will proceed under inserting a computer 11 either speed-controlled or away-controlled, in order to reach one compressing the molding compound 4 proportional molding compound erosion when going back the filling slidegate valve 6 into its starting position. That requires in detail no representation.



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. Filling apparatus to the filling of a form cavity in the form of a press, in particular press for the component industry, is raised with molding compound, with a filling table and a filling slidegate valve, which move molding compound forward in the course of the filling procedure on the aligning form table to over the die cavity and at the bottom into the die cavity emptied, and with press-laterally at least an upper and a lower press stamp for double-sided consolidating of the molding compound, characterised in that in the course of going back the filling slidegate valve (6), moved forward retractable into the die cavity, over the die cavity (1), the lower press stamp (7) synchronously around a given stroke measure and thus the filling slidegate valve (6) from the die cavity (1) pushed up molding compound increasingly also takes back, and that after going back the filling slidegate valve (6) the lower press stamp (7) up to aligning the molding compound-highest (9) with the form table level is gone back and afterwards the Pressvorgang takes place.

2. Filling device according to claim 1, characterised in that of the filling slidegate valves (6) and the lower press stamp (7) under inserting a computer (11) speed-controlled or away-controlled are.

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